

1 LEFT

SPLIT-1

Work Order ID 43603



Page 1

July 1, 2009 10:43:24 AM

Item ID: D3022-1

Accept



Setup Start



Revision ID: B

Item Name: Seat Pan

Stop



Start Date: 7/15/09

Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09

Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3022

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3022 ☐ Dwg Rev: ☐ Prog Rev: ☐☐

*** grind direction along 31.700" ***

☐ 2-Debur if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Work Order ID 43603

July 1, 2009 10:43:24 AM



Page 2

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

1-Form as per Dwg D3022

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Transfer drill Seat Pan From Frame
using D3017-041 *****2-Debur☐*****Transfer drill in D3022-1



Work Order ID 43603

July 1, 2009 10:43:24 AM



Page 3

Item ID: D3022-1

Revision ID: B

Item Name: Seat Pan

Start Date: 7/15/09 Start Qty: 1.00

Required Date: 8/03/09 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

170



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Work Order ID 43603

July 1, 2009 10:43:24 AM



Page 4

Item ID: D3022-1

Revision ID: B

Item Name: Seat Pan

Start Date: 7/15/09

Start Qty: 1.00

Required Date: 8/03/09

Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

200



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Picklist Print

July 1, 2009 10:43:24 AM

Page 1

Work Order ID: 43603

Parent Item: D3022-1RevB

Parent Item Name: Seat Pan

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	111.0120	1.7086			









2024-T3 .032 sheet



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	111.01	
102942	1.5	
105555	5	
106272	8.47	
108595	3	
109240	7.02	
110778	34.02	
111699	49	
18147	3	

Date: Thursday, 20/11/2008 3:34:26 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SEAT PAN
Job Number : 43603	
Estimate Number : 11092	
P.O. Number :	Part Number : D30221 B
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D3022 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : A B
Previous Run : 43392	Material :
Written By :	Due Date : 20/12/2008 Qty: 1 Um: Each
Checked & Approved By : JD 08.11.21	
Comment : Est. C 02.01.23 Revised NG	
Est Rev:D 08-04-16 now water jet DD verified by:EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M2024T3S032 2024-T3 .032 sheet
	
Comment: Qty.: 1.7044 sf(s)/Unit Total: 1.7044 sf(s) 2024-T3 .032 sheet Material: 2024-T3 sheet (QQ-A-250/4) 0.032" Batch: 110778 HB 9-2-10	
2.0	WATER JET FLOW WATER JET
	
Comment: FLOW WATER JET 1-Cut as per Dwg D3022 Dwg Rev: B Prog Rev: B HB 9-2-10 *** grind direction along 31.700" *** 2-Deburr if necessary HB 9-2-10	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 9-2-10	
4.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK 509/02/10 (72)	
5.0	BRAKE NC NC BRAKE
	
Comment: NC BRAKE 509/02/23 (2)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.11.25	2	DRAWING DIMENSIONS ARE INCORRECT ON DWG: <div style="display: flex; justify-content: space-around;"> <div> <u>WAS</u> - 12.325 - 9.425 - 5.550 </div> <div> <u>IS</u> - 12.075 - 9.175 - 5.300 </div> </div> PERMANENT CHANGE	PA	08.11.25	ALL	PA 08.11.25 055 042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:34:26 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT PAN

Job Number: 43603

Part Number: D30221

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Transfer drill Seat Pan From Frame

*****Transfer drill in D3022-1 using D3017-041 *****

2-Deburr

*stock incomplete
09-12-10*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AA

u

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:34:26 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT PAN

Job Number: 43603

Part Number: D30221

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 9.12.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

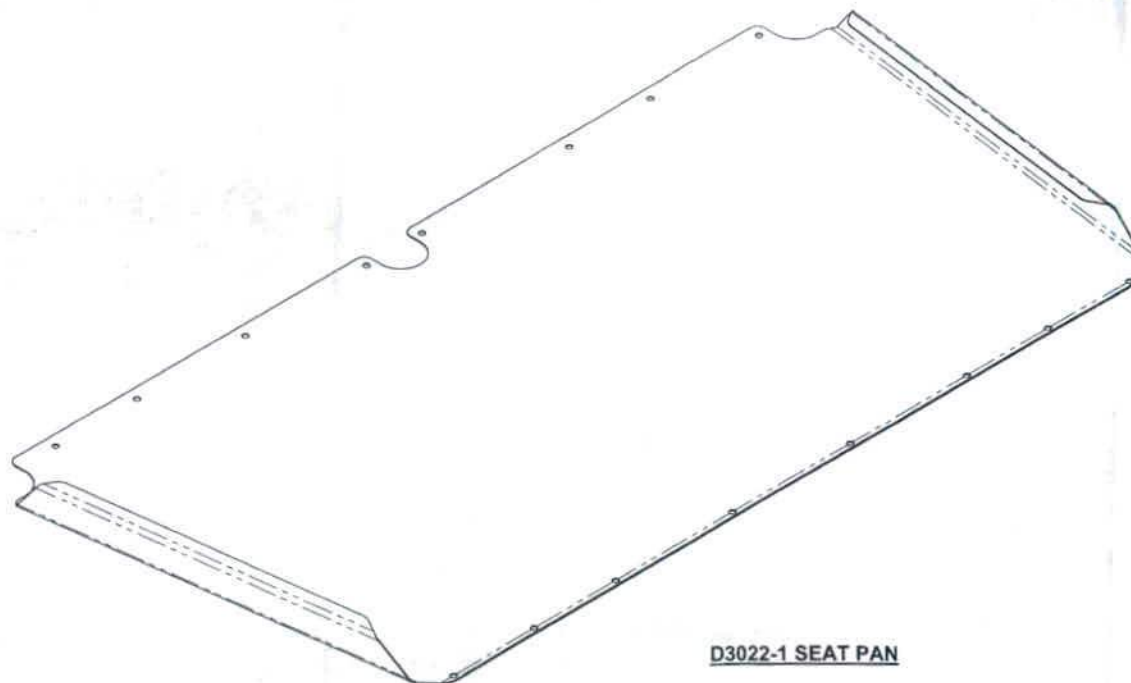
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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D3022-1 SEAT PAN

RELEASED
08/12/13 NW

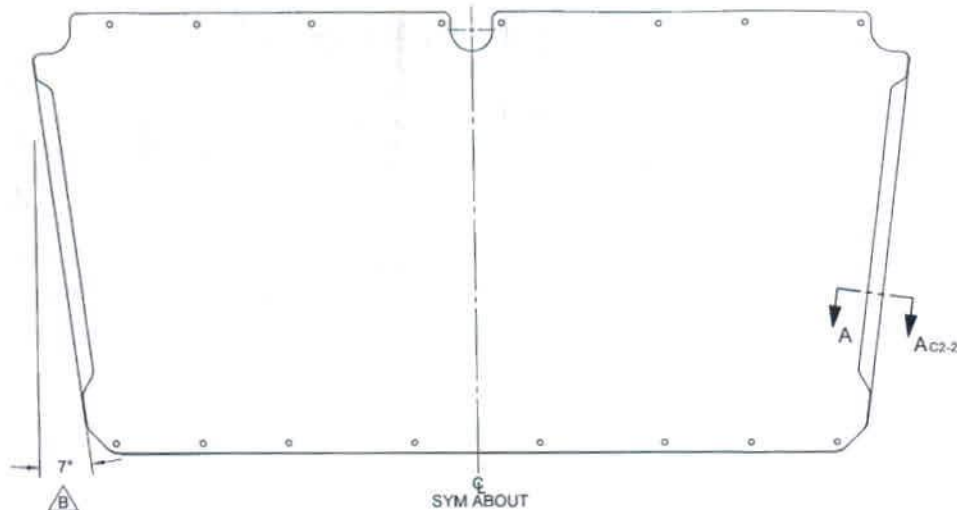
REFERENCE ONLY

43603

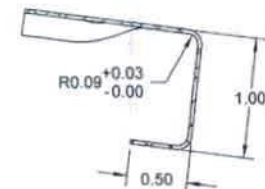
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. SPLIT VIEWS FOR FORMED PART AND FLAT PATTERN. 87.2 7" DIM ADDED. D7-3 12.075 WAS 12.325, D6-3 9.175 WAS 9.425 & D5-3 5.300 WAS 5.550. REASON: DRAFTING ERROR			AJS	08.11.27
A	NEW ISSUE			CP	01.05.18
REV	DESCRIPTION			BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED		DRAWING NO	REV. B		
MFG. APPR.		D3022	SHEET 1 OF 3		
APPROVED		TITLE	SCALE		
DE APPR.		SEAT PAN	NTS		
DATE	08.11.27				

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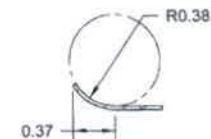
SECRET



D3022-1 SEAT PAN



SECTION A-A C4-2
SCALE 4X



SECTION B-B A6-2
SCALE 4X

RELEASED
08/12/15

NOTES:

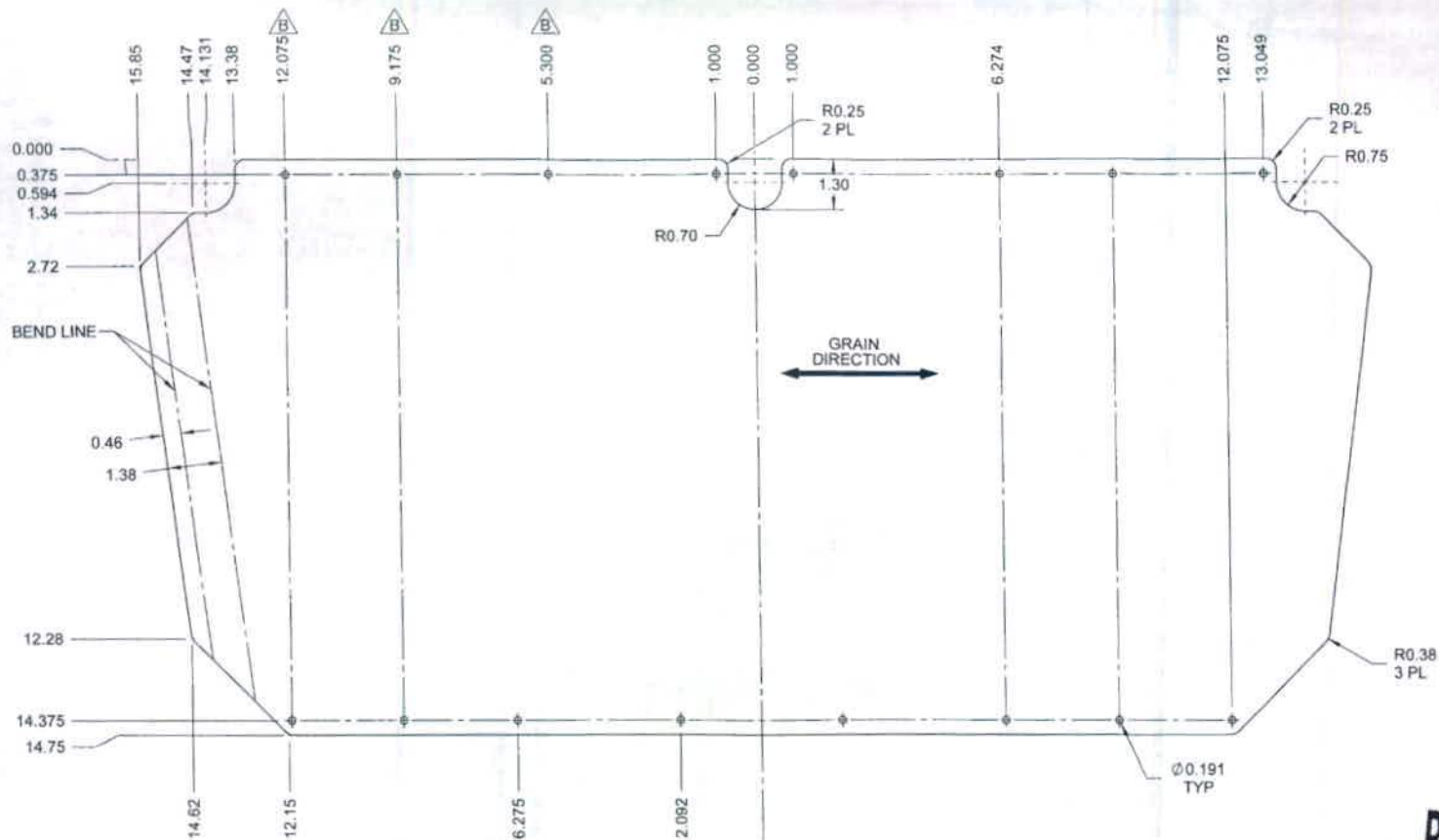
- 1) MATERIAL: MAKE FROM D3022-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3022-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.36 lbs

REFERENCE ONLY

43603

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3022	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT PAN	NTS
DATE	08.11.27	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO REPRODUCTION OR DISSEMINATION OF ANY PART OF IT IS TO BE MADE FOR ANY PURPOSES WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

1907



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI.018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

D3022-1F SEAT PAN

SYM ABOUT
UNLESS OTHERWISE
NOTED

43603

REFERENCE ONLY

RELEASED
08/12/15

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3022	REV. B
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE SEAT PAN	SCALE NTS
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DATE	08.11.27		

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